

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023001**Date Inspected:** 25-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhu Zhong Hai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 13AW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as EP3023-013-033, Edge Plate Splice. The welder is identified as #037779 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-B-P-2213-B-U2-FCM-1.

Segment 13AE

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a UT repair on a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG3007Y-372, Floor Beam I-rib. The welder is identified as #067183 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-345-SMAW-4G (4F)-FCM-repair-1 for WR20637.

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This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a UT repair on a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG300AH-024, Floor Beam to K plate. The welder is identified as #066416 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-345-SMAW-3G (3F)-FCM-repair-1 for WR20640.

Cross Beam 18

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as SP3086-018-015, Side Panel I-rib hold back weld. The welder is identified as #054467 and was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-P-2114-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as SP3089-018-013, Side Panel I-rib hold back weld. The welder is identified as #049769 and was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-P-2114-FCM-1.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as FB4101A-018-037, Floor Beam I-rib hold back weld. The welder is identified as #220066 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-P-2132-ESAB.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as SP3087-018-052, Side Panel I-rib hold back weld. The welder is identified as #220063 and was observed welding in the 4F (overhead) position using approved Welding Procedure Specification WPS-B-P-2134-ESAB.

Bike Path Cantilver 17

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a UT repair on a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as BK001-017-009, Connection Plate. The welder is identified as #040367 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-345-FCAW-3G (3F)-ESAB-repair for WR20676.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a UT repair on a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as BK001-017-005, Connection Plate. The welder is identified as #052763 and was observed welding in the 3G (vertical) position using approved Welding Procedure Specification WPS-345-FCAW-3G (3F)-ESAB-repair for WR20676.

For the above mentioned welding activities ZPMC Quality Control (QC) Inspectors are identified as Wang Li Yang and Zhou Peng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Segment 12CE

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This QA Inspector observed ABF personnel performing Ultrasonic Testing on the Edge Plate to Deck Plate hold back weld and Edge Plate to Side Plate hold back weld, bike path side at east end of segment.

Segment 14 West

This QA Inspector observed 14 west was placed in the OBG trial assembly line up.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Dan	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
